Work Orde July-09-13 11:50		273		*104	273*						Page 1
Revision ID:	D2322 Step Spacer			Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup Star	1.71	S1* S2*
Start Date: Required Date: Reference:		Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*	) ( ) ( )	Cust Item I Customer:	D:					
Approvals:			Date: 13-07-12			ate:	· - — —	F	tun Stai Sto	1/1	R1* R2*
Sequence ID/ Work Center ID		Operation Description	<del></del> <del>-</del> <del></del>	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	sion Nbr					<b></b>				
D2322	Rev (									,	
*100 *100 *100 Waterjet FLOW CNC Waterje 2024 044	ŧ	FLOW WATER JET  Memo  1-Cut as per  Deburr if ne	Dwg D2322 Dwg Rev: ccssary	0.00 0.00 Prog Rev:	2-			<u> </u>	_ 0		Jm 13-08-08
*110* QC Quality Control		QC2- Inspect parts off m  Memo	achine FAI/FAIB	0.00				_7_	_ø		Jm/3-08-08
120 *120* QC Quality Control		QC8- Inspect parts - seco	and check	0.00 37 8	8			7		· ·	

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					_	Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	No.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.		Quality
						Use-as-is		Thern	noforming	Finishing		Rec/Stor	re/Packaging		Other
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Root		Ī			Desci	ription of work order update		Initial	Act	tion		Sign &	-		Ī
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Handling/Pre															
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Operator															
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Landi	ng Gear					General		_							_
	Ben	ding				Bend		Folio/F	rogram		C	Outside Dim	ensions		Pressure/Forced
	Cen	itre No	t Concer	ntric	L.	BOM/Route		Grain			c	Over/Under	tolerance		Set-up
	Cra	cks			<u> </u>	Broken/Damage/Defect		Hardwa	re		Р	art Incorred	ct		Temperature/Cure
	Crir	np/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Р	art Lost/Mi	ssing		Weld
	Cuf	fs				Contamination		Instruct	ions Incomplete/L	Jnclear [	Р	art Moved			Wrong Stock Pulled
	Cru	shing				Countersink		Misalig	ned/off center		P	ositioned V	Vrong		-
	Hea	st Treat	t			Cut Too Short		Mislabe	eled		P	ower Loss/	Surge		Other
	Insp	pection	Strip in	Tube		Drawing		Misread	d	-					
	Mai	rks/Cha	atter			Drill Holes		Off-set			_				
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	l lw/a⋅	ve/Twi	st in Tuh	10		Fit/Function	I	lout of	Contionco						

Work Orde		4273		*10	427	73*					- ·	Page 2	
Item ID: Revision ID: Item Name:	D2322 Step Spacer		T. 7 T.T. T.	Accept	*N	1900	<b>040</b>	100	<b>)*</b> s	etup Star Stop	I ZI -	S1* S2*	
Start Date: Required Date: Reference:	7/09/13 7/09/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*			Cust Item I Customer:	D:						
Approvals:	Process Piz	nn:	Date:	_ •			ate:	_	R	tun Star Stoj	, "I <b>V</b> I	R1*	
Sequence ID/ Work Center II		Operation Description NC BRAKE	Date	Set Up/ Run Hours 0.00		Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	-	
*130* Brake NC Brake NC		Memo	Dwg D2322	0.00					_ <del>_</del>			B	63/20
140 *1 <b>4</b> 0*		QC5- Inspect part compl	leteness to step on W/O	0.00 DAS 0.00 27	1				7		ramin was no make a Bar A		
QC Quality Control		Memo		_ 9-89	l'ad								:
<sup>150</sup> <b>*15</b> Ω*		Chemical Conversion Co	oat per QSI005 4.1	0.00					_7_	R	n/3	8.26	
HandFinish		Memo		0.00								_	

Hand Finishing

DQA:		_ Date:										•	TO AC
					WORK ORDER NON	-C(	ONFO	RMANCE / UP	DATE				AEROSPACE
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Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS		
Tronk orde				_	Rework	1		Skid-tube	Crosstube	1	Water Jet		Engineering
Part N	0.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.		Quality
					Use-as-is			noforming	Finishing		re/Packaging	7	Other
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Root				Desc	ription of work order update	!	nitial	Actic	on .	Sign &			
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Landin F	<del>-</del>			r	General	_	}		_	1			<i>r</i> = .
-	Bending			_	Bend DOM/Parks	_	1	Program	<u> </u>	Outside Dim	<b>⊢</b>	—;	ressure/Forced
-		lot Concer	itric	$\vdash$	BOM/Route	_	Grain		-	Over/Under		<b>-</b>	et-up
}-	Cracks	inde (Dinada	0.44	-	Broken/Damage/Defect	_	Hardwa			Part Incorred	<b>⊢</b>	_	emperature/Cure
-		ink/Ripple	/wave	-	Burrs	<u> </u>	1	ion Incomplete/Unq	· -	Part Lost/Mi	ssing	-1	Veld
}	Cuffs			$\vdash$	Contamination	_	-₹	ions Incomplete/Un	iclear	Part Moved		\^	Vrong Stock Pulled
-	Crushing			-	Countersink	<del> </del>	•	gned/off center	<b>-</b> -	Positioned V		٦,	
	Heat Tre		Tuba	<u> </u>	Cut Too Short	$\vdash$	Mislabe		L	Power Loss/	ourge	10	ther
	<b>─</b>	on Strip in	iube	$\vdash$	Drawing Drill Holes	<u> </u>	Misread	ג					
}	Marks/C					-	Off-set	Talibantia-			<u> </u>		
		Sequence wist in Tub		-	Finish Fit/Function	_	1	Calibration Sequence		<del></del>			
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Work Orde July-09-13 11:5		04273		*104	1273*						Page 3
Item ID: Revision ID: Item Name:	D2322 Step Spacer			Accept	*N900	<u>0</u> 40	100	<b>)*</b> s	Sto	1 72	S1* S2*
Start Date: Required Date: Reference:	7/09/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	ID:					:
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Sequence ID/ Work Center II 160 *160* QC Quality Control	 D .	Operation Description QC7-Inspect Chemical C	Conversion Coat	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Packaging Packaging		Identify as per dwg & St Memo	ock Location	0.00				X	**************************************	<i>-</i> /	J3/8
180 *180* QC Quality Control		QC21- Final Inspection  Memo	- Work Order Release	0.00				N	ルゴ	13-08-	23

pl 13-08-22

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QA Closed:		Date:			WORK ORDER NON-	-CC	JNFOI	RMANCE / U		Vork Order up	odate only	AEROSPACE
Work Orde		•		-	DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part N					Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N				<del></del>	Use-as-is Suspected Unapproved			noforming Large Fab	Finishing Composite	_	re/Packaging Supplier	Other
Root		1		Desc	ription of work order update		nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
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Landii	ng Gear				General							
	Bending				Bend		Folio/P	rogram	Γ	Outside Dim	ensions	Pressure/Forced
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	Cracks				Broken/Damage/Defect		Hardwa	re	Γ	Part Incorre	ct	Temperature/Cure
	Crimp/k	ink/Ripple	e/Wave		Burrs		Inspecti	ion Incomplete/Ur	nqualified	Part Lost/Mi	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled
	Crushin	g			Countersink	П	Misalig	ned/off center	Γ	Positioned V	Vrong	<del></del>
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	Marks/0	hatter			Drill Holes		Off-set					
	Turning	Sequence	<u>!</u>		Finish		Out of 0	Calibration				<del></del>
	_	wist in Tu			Fit/Function	$\Box$	1001.069	Compando				

July-09-13 11:50:38 AM

Work Order ID:

104273

Parent Item:

D2322

Parent Item Name:

Step Spacer

Start Date: 7/09/13

Required Date: 7/09/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 05-11-07 JLM

IPP Rev;B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item 1D	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	365.3877	0.203	1 <del>.28210</del> 52			<u>m 13-08</u> -0
				Location		Loc Oty	Lo	c Code					
				MAT022		365.3876922				<u>.</u>			
				1206	05	65.8254832							
				1211	97	57.187894							
				1221	36	31.78							
				1232	17	20.094315							
				1249	87	190.5			129	EBP			

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						<b>WORK ORDER NON</b>	-C(	ONFO	RMANCE / U	IPDATE					AEROSPACE
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Work Ord	er:				·	DISPOSITION				AGAINST	DEP	ARTMENT,	/PROCESS		
	•					Rework	]		Skid-tube	Crosstube			Water Jet		Engineering
Part I	No.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
İ	•					Use-as-is	1	Therr	noforming	Finishing		Rec/Sto	re/Packaging		Other
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Root				l	Desc	ription of work order update	Ι.	initial	Ac	tion	T	Sign &			
Cause		Date	Step	Qty		or non-conformance	Cr	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
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		Bending			<u> </u>	Bend		Folio/P	rogram		c	Outside Dim	ensions		Pressure/Forced
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	Ш	Crimp/Kir	nk/Ripple	/Wave		Burrs	匚	Inspect	ion Incomplete/U	nqualified	P	art Lost/Mi	ssing		Weld
	Ш	Cuffs				Contamination	L	Instruct	ions Incomplete/	Unclear	P	art Moved			Wrong Stock Pulled
	Ш	Crushing				Countersink		Misalig	ned/off center		P	ositioned V	Vrong		
	Ш	Heat Trea	at			Cut Too Short		Mislabe	eled		P	ower Loss/	Surge		Other
		Inspectio	n Strip in	Tube	L	Drawing		Misread	t						
		Marks/Ch	atter		L	Drill Holes		Off-set			_				
	Ш	Turning S	equence			Finish		Out of (	Calibration		_				
l		Wave/Tw	ist in Tub	e	1	Fit/Function	[ ]	Out of 9	Sequence						

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DART AEROSPACE LTD	Work Order:	104273
Description: Step Spacer	Part Number:	D2322
Inspection Dwg: D2322 Rev: C		Page 1 of 1

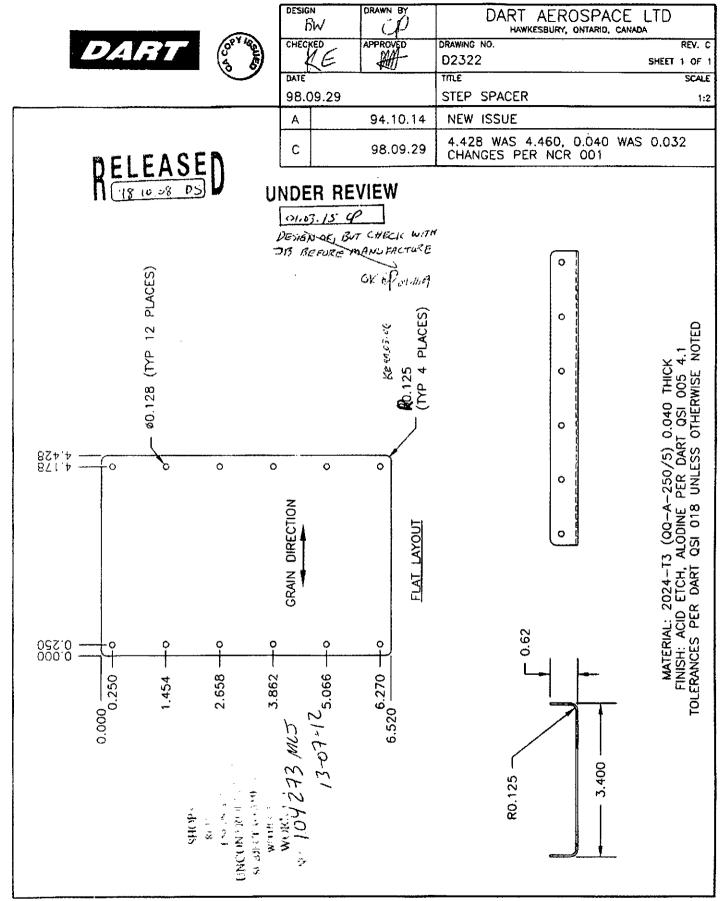
	FIR	ST ARTICLE	INSPEC	TION CH	ECKLIST		
		X First A	rticle [	Pro	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method (		omments
0.250	+/-0.005	0.254"	_		V	Jkm	<u> </u>
4.178	+/-0.005	4.179"	_		γ		
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L A	04.10.12	New Issue	P/O D2582	<del></del>	KJ/JLM 🚓	
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